

Date: Wednesday, 5/16/2007 1:45:25 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: DART 4-MAN 3-POINT AFT FACING SHOULDER
Job Number	: 32421			HARNESSE ASSEMBLY
Estimate Number	: 12867			
P.O. Number	: N/A		Part Number	: D412702045B
This Issue	: 5/16/2007	S.O. No. : N/A	Drawing Number	: D412702045B
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A	Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 32331		Material	: N/A
Written By	:		Due Date	: 5/23/2007
Checked & Approved By	:		Qty:	1
Comment	:	est rev A 07.05.10 new issue EC	Um:	Each

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL			
Photocopy bluefile & type labels per PPP D412-702-045B CHG001		R507/05/18 (1)	
2.0	D412702111B	HARNESS ASSEMBLY	
Comment: Qty.: 2.0000 Each(s)/Unit		Total : 4.0000 Each(s)	
HARNESS ASSEMBLY		B32337 X	
3.0	D412702113B	HARNESS ASSEMBLY	
Comment: Qty.: 2.0000 Each(s)/Unit		Total : 4.0000 Each(s)	
HARNESS ASSEMBLY		B32338 X	
4.0	D3572041	GUIDE ASSEMBLY	
Comment: Qty.: 2.0000 Each(s)/Unit		Total : 4.0000 Each(s)	
GUIDE ASSEMBLY		B31870, X (2)	
5.0	AN416A	Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit		Total : 4.0000 Each(s)	
Bolt		M18949, X (1)	
6.0	AN425A	BOLT	
Comment: Qty.: 4.0000 Each(s)/Unit		Total : 8.0000 Each(s)	
BOLT		M104438, X (1)	
		7/5/24 SP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:45:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 4-MAN 3-POINT AFT FACING SHOULDER HARNESS
ASSEMBLY

Job Number: 32421

Part Number: D412702045B

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

batch: M103691 X

8.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

batch: M102552 X

7/5/24 59

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 7/5/24

CY 67105124 ①

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-045B CHG001

Location: _____

PPP Rev: _____

Rev Draft 7/5/24 SQ

Job Completion



QC 21 Final inspection w/o release 7/5/24

U 7/5/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1*	1*			1*	D3569-3	DECAL
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL

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WORK ORDER

NO. 32421

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Revision: D

Date: 07.04.12

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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 Revision: D
 Date: 07-04-12
 WORK ORDER
 NO. 32421

Date: Monday, 5/14/2007 7:15:02 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HARNESS ASSEMBLY
Job Number : 32337	
Estimate Number : 12859	
P.O. Number : <i>N/A</i>	Part Number : D412702111B
This Issue : 5/14/2007 S.O. No. : <i>N/A</i>	Drawing Number : ICA D412-702 P.79
Prsht Rev. : <i>NC</i>	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : <i>D</i>
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/15/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>10</i> Um: Each
Comment : est rev A 07.05.11 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

*PTD*

Comment: DOCUMENT CONTROL
 type labels per PPP D412-702-111B CHG001

2.0	D35701	BRACKET
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 BRACKET
 batch: *B 31866*

✓

3.0	D3579047	SHOULDER HARNESS LH
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 SHOULDER HARNESS RH
 batch: *B 32116*

✓

4.0	MS24694S50	Screw
-----	------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Screw
 batch: *M 14206*

✓

5.0	AN960JD10L	Washer
-----	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Washer
 batch: *M 101291-*

m/07/05/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
ml 07/05/16	1	w/o split	ml	07/05/16	2	[Signature]	[Signature]	
0705-24	8	Applied marine Adhesive Sealant Contact na 104534 cement na 102565	ml	07/05/16				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/14/2007 7:15:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HARNESS ASSEMBLY

Job Number: 32337

Part Number: D412702111B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

batch: M103641-20

M 103641 (20)

7.0

D35693

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

DECAL

batch: 32086

m107/05/17

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg ICA D412-702 p.79

~~07-05-16~~ (10)
mf 07-05-23 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

070524 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-111B CHG001

Location:

PPP Rev: D1011

07/05/24 (2)

Job Completion




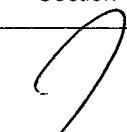

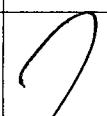
QC 21 Final inspection W/ release (2)

07-05-24

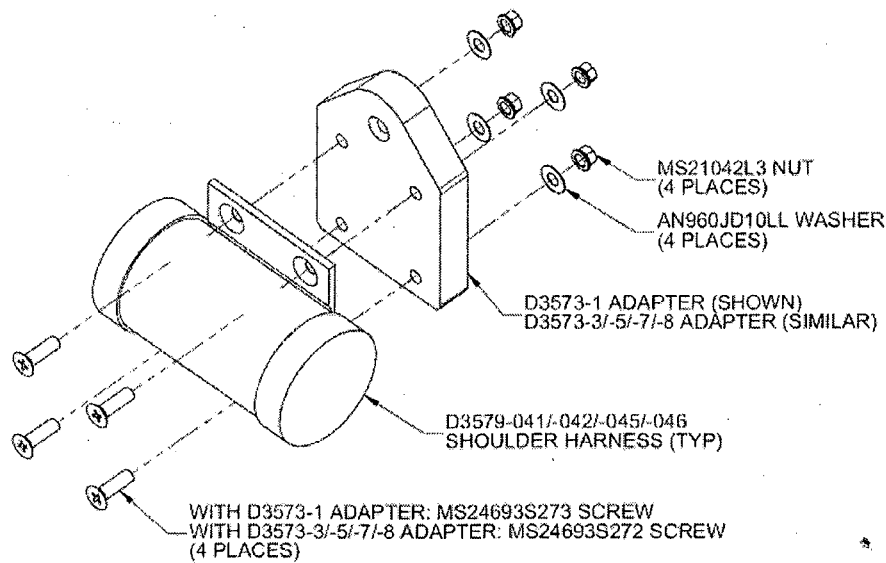
M103641

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

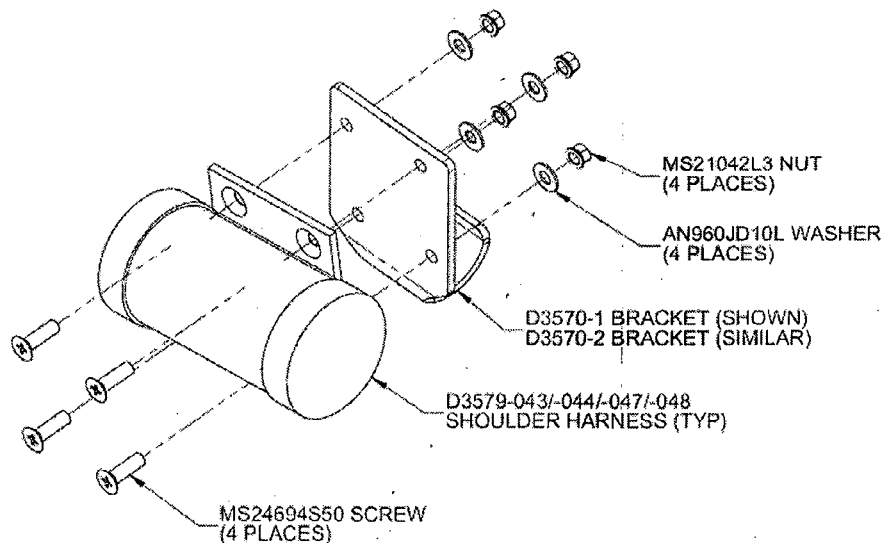
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/24	8.0	D3569-3 does not stick to the buckle, even with the recommended adhesive. 3M Fastcure 5200	 07/05/24	Apply a mild coat of contact cement to bond the label to the buckle. M.102565	Srb 07/05/24	 07/05/24	 07/05/24	 07/05/24

NOTE: Date & initial all entries



**DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND
D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B HARNESS ASSEMBLIES**
(BELTS, K6.2 CLIP AND D3569-1/-2/-3 DECAL NOT SHOWN)



DETAIL 'L' D412-702-111A/-111B/-113A/-113B HARNESS ASSEMBLIES
(BELTS AND D3569-1/-2/-3 DECALS NOT SHOWN)

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WORK ORDER
NO. 32337

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Date: Monday, 5/14/2007 7:15:15 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HARNESS ASSEMBLY
Job Number	: 32338		
Estimate Number	: 12860		
P.O. Number	: N/A	Part Number	: D412702113B
This Issue	: 5/14/2007 S.O. No. : N/A	Drawing Number	: ICA D412-702 P.79
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	:	Material	: N/A
Written By	: <u>07.05.14</u>	Due Date	: 5/15/2007
Checked & Approved By	: <u>07.05.14</u>	Qty:	<u>10</u> Um: Each
Comment	: est rev A 07.05.11 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

DC

DOCUMENT CONTROL



PTO

Comment: DOCUMENT CONTROL

type labels per PPP D412-702-113B CHG001

2.0

D35702

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

BRACKET

batch: B31867

3.0

D3579048

SHOULDER HARNESS RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

SHOULDER HARNESS RH

batch: B32117

4.0

MS24694S50

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: M14206-

5.0

AN960JD10L

Washer

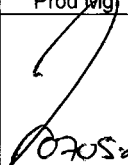
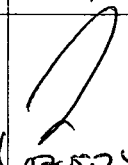


Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

batch: M1-1291-
ml 07/05/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
ml 07/05/16	1	w/o split	ml	07/05/16	2	 070524	 070524	
07-05-24 9		Applied Macro Adhesive Sealant m104524 contact cement m102525	ML	07-05- 24				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/14/2007 7:15:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HARNESS ASSEMBLY

Job Number: 32338

Part Number: D412702113B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

batch:

M104215 39X M103641-1X

7.0

D35693

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

DECAL

batch:

B32086

✓
ml07/05/17

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg ICA D412-702 p.79

mf 07-05-23 (2)

(PTO)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-24 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-113B CHG001

Location:

PPP Rev:

07-05-24

07-05-24 (2)

Job Completion







QC21 Final inspection w/o release 07-05-24

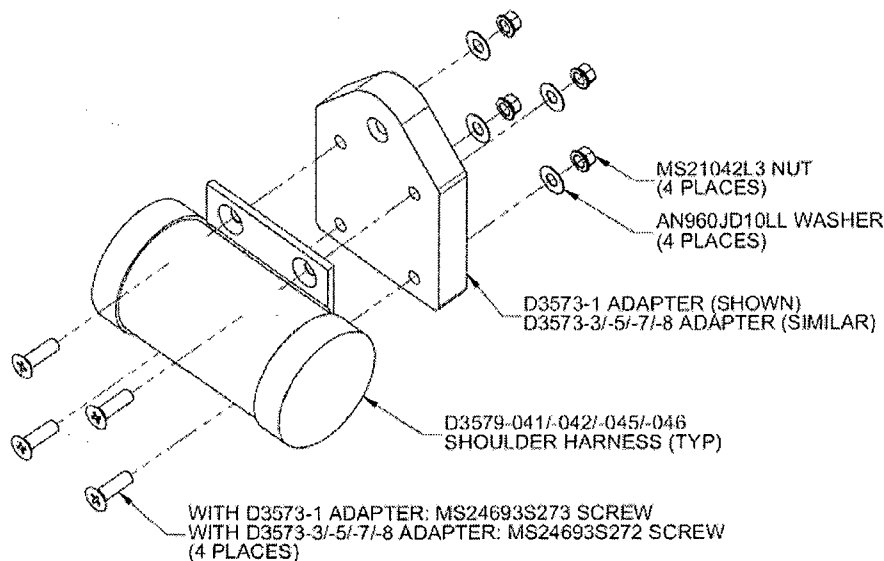
h 07-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

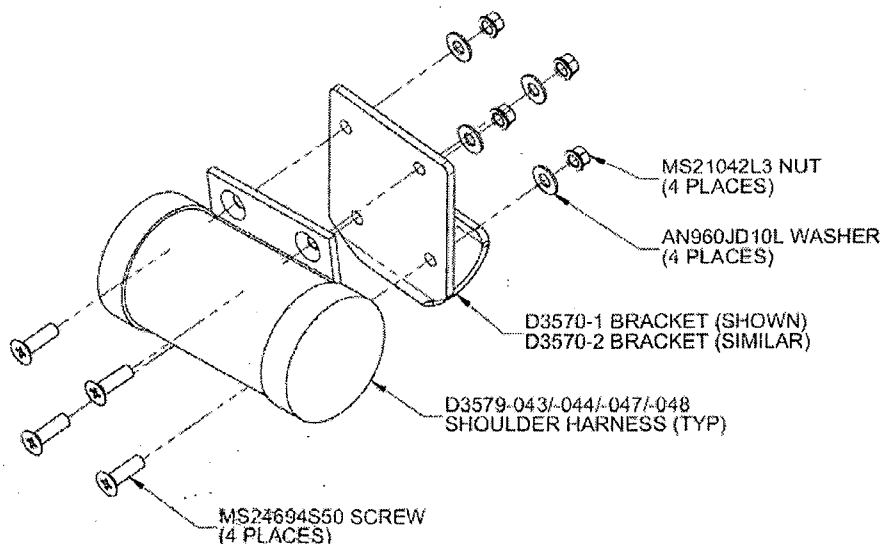
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/24	8.0	D3569-3 does not stick to the buckle, even with the recommended adhesive 3M fast cure 5200	 07/05/24	Apply a light coat of contact cement to bond the label to the buckle M102525	SB 07/05/24	 07/05/24	 07/05/24	 07/05/24

NOTE: Date & initial all entries



**DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND
D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B HARNESS ASSEMBLIES**
(BELTS, K6.2 CLIP AND D3569-1/-2/-3 DECAL NOT SHOWN)



DETAIL 'L' D412-702-111A/-111B/-113A/-113B HARNESS ASSEMBLIES
(BELTS AND D3569-1/-2/-3 DECALS NOT SHOWN)

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